

Work Order ID 41838

June 26, 2009 10:37:11 AM

Deren  
69096



powder coating

24/9/08

Page 1

Item ID: D3391-021

Revision ID: H

Item Name: Fwd Tube Assembly

Start Date: 15/07/2009 Start Qty: 1.00



Required Date: 03/08/2009 Req'd Qty: 1.00



Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D3391	Rev H
-------	-------

100  
  
Skidtubes

0.00

Skidtubes  
  
Memo  
Cut extrusion to 46.52 +0.010 -0.020

0.00

110  
  
BENDING MACHINE - SKIDTUBES

0.00

CNC Bend 1  
CNC Delta 100 Bender  
Memo  
Bend as per Dwg D3391 Using Bend Prog 3391021

0.00

120  
  
QC5- Inspect part completeness to step on W/O

0.00

QC  
Control

0.00

**Work Order ID 41838**

June 26, 2009 10:37:12 AM



Page 2

Item ID: D3391-021

Accept



Setup Start



Revision ID: H

Stop



Item Name: Fwd Tube Assembly

Start Date: 15/07/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 1.00



Customer:

**Reference:**

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC: \_\_\_\_\_

Date:

SPC (Y/N):

Date:

Stop

**Sequence ID/  
Work Center ID****Operation  
Description**Set Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



HAAS CNC VERTICAL MACHINING #1

HAAS I

**Memo**

0.00

0.00

✓

140



QC2- Inspect parts off machine FAI/FAIB

0.00

0.00

✓

QC

Quality Control

150



CONVENTIONAL MILLING MACHINE

0.00

0.00

✓

Mill Conv

Conventional Milling Machine

**Memo**

Drill X1 Aft cap as per Dwg D3391 .1875" dia

# Work Order ID 41838

June 26, 2009 10:37:12 AM



Page 6

Item ID: D3391-021

Accept



Setup

Start



Revision ID: H

Stop



Item Name: Fwd Tube Assembly

Start Date: 15/07/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

250



QC

Quality Control

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

0.00

1

Ø

6/10/2009

0.00

260



Packaging

Packaging

Identify as per dwg & Stock Location: W10

0.00

D412-742-043/B68642

1 Ø 6/10/2009

Memo

0.00

270



Skidtubes

Skidtubes

0.00

Memo

0.00

\*\*\*\*install D3591-1 spacer as per DSI9364 \*\*\*\*

1 Ø 6/10/2009

**Work Order ID 41838**

June 26, 2009 10:37:12 AM



Page 7

Item ID: D3391-021

Accept



Setup Start



Revision ID: H

Stop



Item Name: Fwd Tube Assembly

Start Date: 15/07/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 1.00



Customer:

**Reference:**

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



Stop



QC:

Date:

SPC (Y/N):

Date:

**Sequence ID/  
Work Center ID****Operation  
Description**Set Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

280



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/04/29

MF  
11-04-29

# Picklist Print

June 26, 2009 10:37:10 AM

Page 1

Work Order ID: 41838



Parent Item: D3391-021RevH



Parent Item Name: Fwd Tube Assembly

Start Date: 15/07/2009

Required Date: 03/08/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ AELS-1032-225 INSERT		Purchased		No		100	Each	0.0000	10.0000	10X	11/04/28	W110768
✓ D6013-047RevA Skidtube Material		Manufactured		No		220	Each	0.0000	1.0000			
✓ AELS-1032-130 INSERT		Purchased		No		260	Each	0.0000	2.0000	X2	11/04/28	M11733
✓ AN3C4A BOLT		Purchased		No		260	Each	0.0000	10.0000	X10	11/04/28	M116924
✓ AN960C10L NAS1149C0332R washer		Purchased		No		260	Each	0.0000	10.0000	X10	11/04/28	M11729
✓ D3401-041RevB Tow Cap Assembly		Manufactured		No		260	Each	0.0000	1.0000	X1	11/04/28	B46029
✓ D3564-13RevD Wearshoe		Manufactured		No		260	Each	0.0000	1.0000	X1	11/04/28	1366549
✓ D3566-13RevC Gasket		Manufactured		No		260	Each	0.0000	1.0000	X1	11/04/28	B66550
✓ D3670-4-200RevA SPACER		Manufactured		No		260	Each	0.0000	4.0000			

# Picklist Print

June 26, 2009 10:37:11 AM

Page 2

Work Order ID: 41838



Parent Item: D3391-021RevH

Parent Item Name: Fwd Tube Assembly

Start Date: 15/07/2009

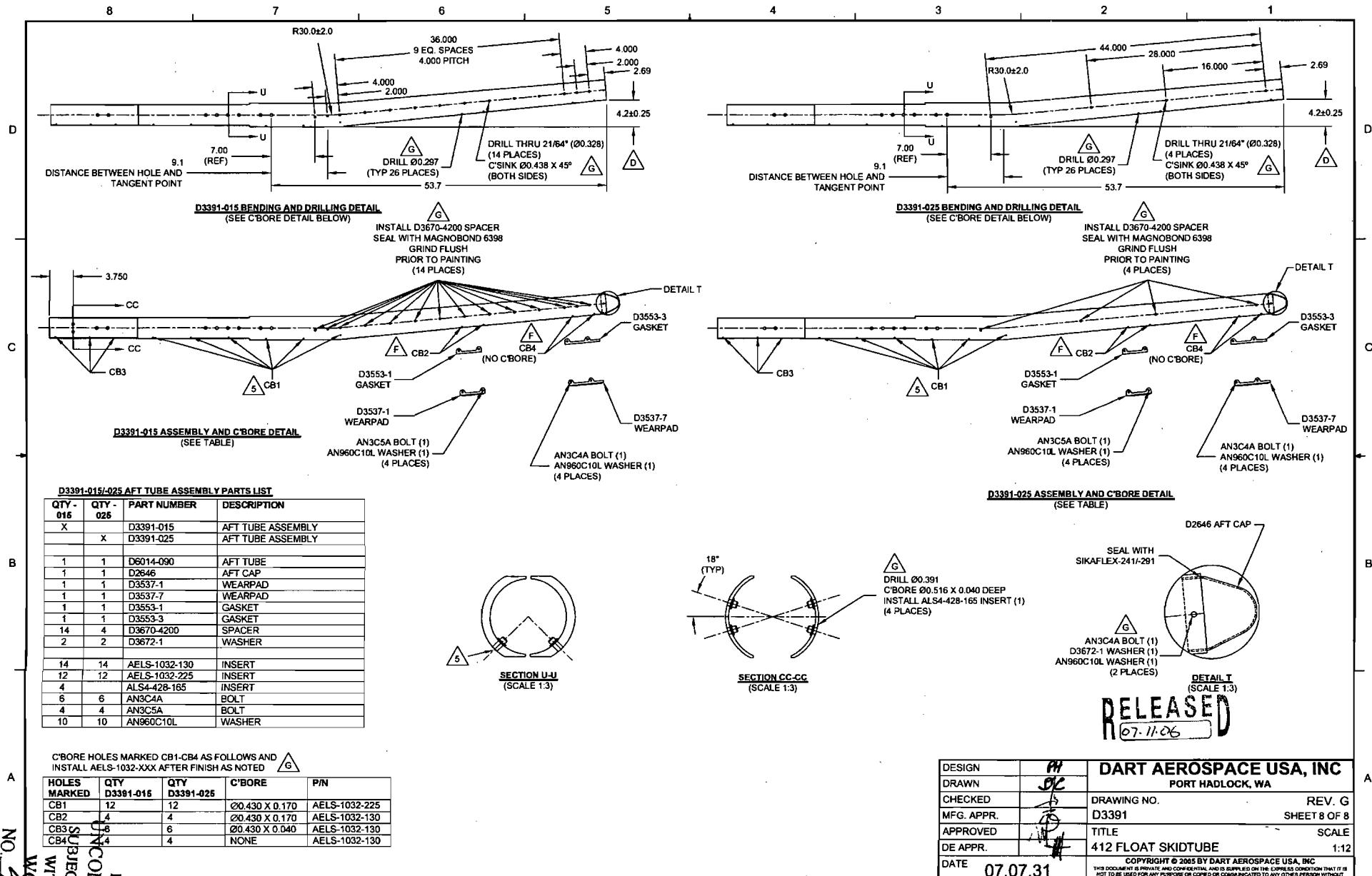
Required Date: 03/08/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ D3672-1RevB Phenolic Washer		Manufactured		No		260	Each	0.0000	4.0000	1352-505	 (x) M 16/07/2009	



NO. <u>223</u>	WORK ORDER	SHOP COPY
		RETURN TO
		ENGINEERING
SUBJECT: TO AMENDMENT		
WITHOUT NOTICE		
JUN 1974		
CB3 CB4		

DESIGN	PH	DART AEROSPACE USA, INC		
DRAWN	JK	PORT HADLOCK, WA		
CHECKED		DRAWING NO.	REV. G	
MFG. APPR.		D3391	SHEET 8 OF 8	
APPROVED		TITLE	SCALE	
DE APPR.		412 FLOAT SKIDTUBE	1:12	
DATE	07.07.31	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE USA, INC. COPYRIGHT © 2005 BY DART AEROSPACE USA, INC. NOT TO BE USED FOR ANY PURPOSE OR COPY OR COMMUNICATE THIS DOCUMENT TO ANY PERSON		

Date: Thursday, 04/09/2008 1:24:42 PM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: FWD TUBE ASSEMBLY		
Job Number	: 41838			Part Number	: D3391021		
Estimate Number	: 10467			Drawing Number	: D3391 REV G		
P.O. Number	:			Project Number	: N/A		
This Issue	: 04/09/2008 S.O. No. :			Drawing Revision	: G		
Prshrt Rev.	: NC			Material	:		
First Issue	: / / Type : SKIDTUBES			Due Date	: 25/09/2008 Qty: 1 Um: Each		
Previous Run	: 41837						
Written By	:						
Checked & Approved By	: <u>JUL 08.9.04</u>						
Comment	: Est. A 05.09.13 New issue KJ/JLM						
	Est. B 06.02.10 Dwg rev.D ecn 773 EC						
	Est. C 06.05.02 Added inspections EC						
	est D 07.03.13 rev F dwg EC						
	est E 07.11.07 revG dwg ecn1053P EC verified by: DD						
	Est Rev:f ECN 1056 07-11-12 DD verified by: EC						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D6013047	Skidtube Material	
<b>Comment:</b> Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) SKIDTUBE MAT'L Pick: Qty Part Number Description Batch 1 D6013-047 Extrusion <u>26547</u> <i>RT 08-09-09</i>			
2.0	SKIDTUBES 1	SKIDTUBES RESOURCE 1	
<b>Comment:</b> LANDING GEAR RESOURCE 1 Cut extrusion to 46.52 +0.010 -0.020 <i>RT 08-09-09</i>			
3.0	BENDING	BENDING MACHINE - SKIDTUBES	
<b>Comment:</b> Nc bender Bend as per Dwg D3391 Using Bend Prog 3391021 <i>RT 08-09-09</i>			
4.0	QC5	INSPECT WORK TO CURRENT STEP	
<b>Comment:</b> INSPECT WORK TO CURRENT STEP <i>S 08/09/09 (EO)</i>			

W/O:

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date &amp; initial all entries

# Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD TUBE ASSEMBLY

Job Number: 41838

Part Number: D3391021

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA590 Rev. F & Dwg D3391 Rev. CT  
Identify as D3391-1

2-Deburr

JL 08/09/07

6.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

JL 08/09/07

7.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Drill X1 Aft cap as per Dwg D3391 .1875" dia mnf 08/09/11

8.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE mnf 08/09/11

9.0 QC8 SECOND CHECK



Comment: SECOND CHECK

Surf 08-09-11

①

10.0 SKIDTUBES 1 SKIDTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill float bag holes as per Dwg D3391 using DT8798(Do not open tow cap holes to finish size)  
(ONLY DRILL HOLES MARKED "A")

2-Drill Remaining two holes for tow cap using DT 8819 Locating off of .1875" holes drilled in previous step

3-Open tow cap holes to .208" as per Dwg D3391

4-Open Tow Ring hole to .640" as per Dwg D3391

5-Deburr & Scribe Batch number Inside aft end.

6-Transfer drill D3391-021 with D3391-023

8-9-12  
8-9-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 04/09/2008 1:24:42 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD TUBE ASSEMBLY

Job Number: 41838

Part Number: D3391021

Job Number:



Seq. #:	Machine Or Operation:	Description :
11.0	QC5	INSPECT WORK TO CURRENT STEP 
12.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 
13.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 
14.0	SPACER	Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s) SPACER batch: B 41115  u 7-9-22 
15.0	SKIDTUBES 1	SKIDTUBES RESOURCE 1 
16.0	QC5	INSPECT WORK TO CURRENT STEP 
17.0	POWDER COATING	POWDER COATING Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 START TIME: 8:15 OVEN TEMPERATURE: 320 °F 

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 04/09/2008 1:24:42 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD TUBE ASSEMBLY

Job Number: 41838

Part Number: D3391021

Job Number:



Seq. #: Machine Or Operation:

FINISH TIME:

245  
8

Description:

ML 08/09/08  
12

18.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11/01/28 X1

19.0 ✓ ALS41032130

Insert



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

INSERT

batch: \_\_\_\_\_

or equivalent

per QSI 017

20.0 ✓ ALS41032225

Insert



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

INSERT

batch: \_\_\_\_\_

or equivalent

per QSI 017

21.0 ✓ HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install Inserts as per Dwg

22.0 ✓ QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

23.0 ✓ D3401041

Tow Cap Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Tow Cap Assembly

Pick:

Qty

Part Number

Description

Batch

1

D3401-041

Tow Cap

\_\_\_\_\_

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 04/09/2008 1:24:42 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD TUBE ASSEMBLY

Job Number: 41838

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0 ✓ D356413

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

25.0 ✓ D356613

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

26.0 ✓ D36721

Phenolic Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

PHENOLIC WASHER

27.0 ✓ AN3C4A

BOLT



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bolt

Pick:

Qty	Part Number	Description	Batch
4	AN3C4A	Bolt	_____

28.0 ✓ AN960C10L

washer



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

washer

29.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install tow Cap as per Dwg D3391

Identify as D3391-021

30.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Inspect thread of each insert using DT8821

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 04/09/2008 1:24:42 PM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD TUBE ASSEMBLY

Job Number: 41838

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description :

31.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

32.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	41838
Description: Float Skidtube (412)	Part Number:	D3391-1
Inspection Dwg: D3391	Rev: G	Page 1 of 1

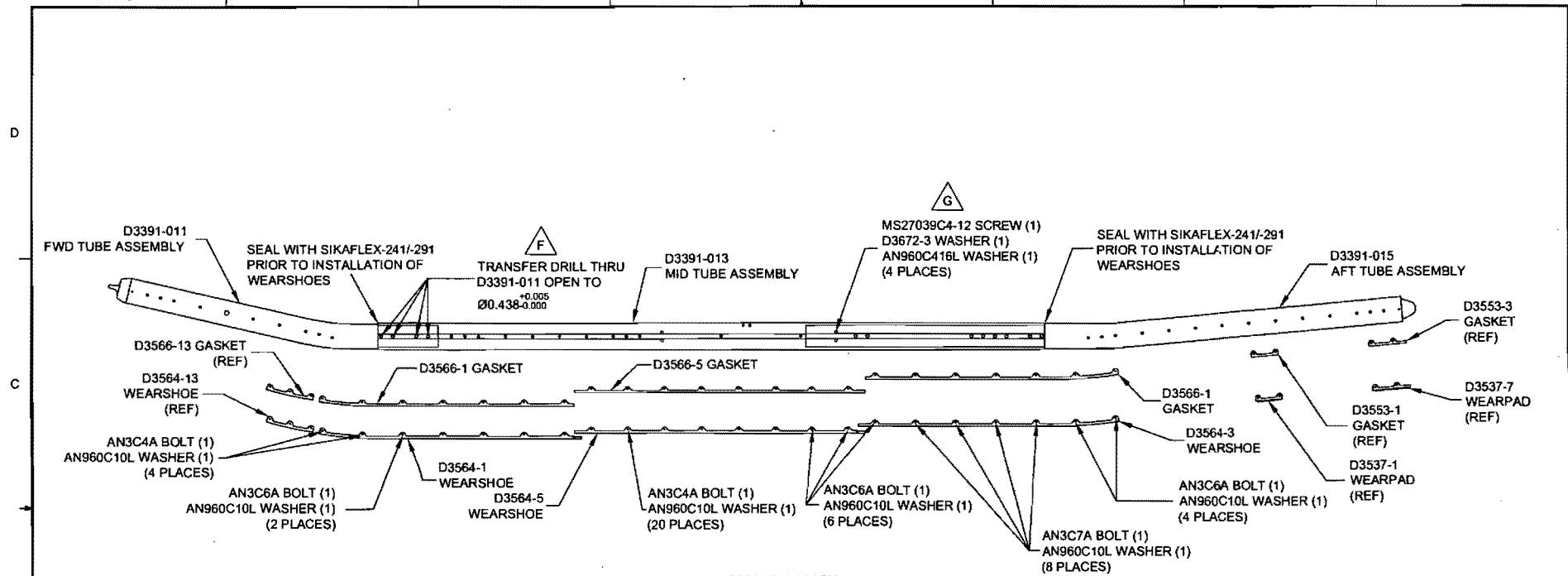
## **FIRST ARTICLE INSPECTION CHECKLIST**

## X First Article      Prototype

Measured by:	JL	Audited by:	✓	Prototype Approval:	N/A
Date:	08/09/07	Date:	08.09.07	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.04.27	New Issue P/O D3391-011/-021	KJ/JLM	
B	06.06.19	Tolerances revised per D3391 Rev. E	KJ/JLM	
C	07.03.21	Dimensions removed per Dwg rev. F	KJ/JLM	
D	07.11.23	Dwg Rev. updated	KJ/EC/DD	KA

8 7 6 5 4 3 2 1

RELEASED  
07.11.06

## D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST

QTY	PART NUMBER	DESCRIPTION
1	D3391-041	FLOAT SKIDTUBE ASSEMBLY
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-2	WEARSHOE
1	D3564-3	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
1	D3567-2	GASKET
24	AN3C4A	BOLT
12	AN3C6A	BOLT
32	AN960C10L	WASHER
48	AN960C416L	WASHER
1	MS27039C4-12	SCREW
1	AN960C416L	WASHER

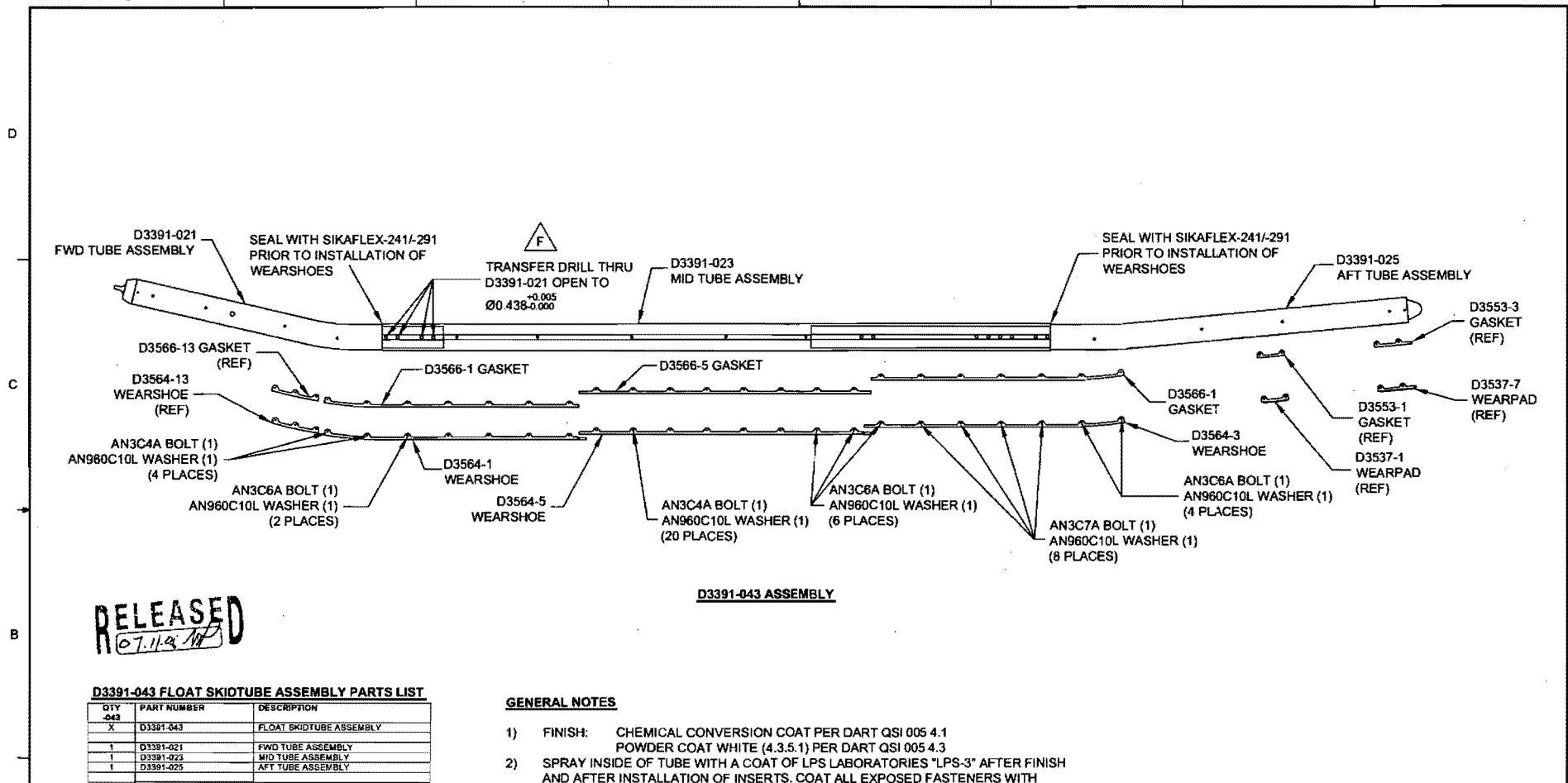
## GENERAL NOTES

- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL  $\varnothing 0.297$  SIZE HOLES FOR WEARSHOE INSERTS. CBORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED.

G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS. DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>PH</i>	DART AEROSPACE USA, INC	
DRAWN	<i>SP</i>	PORT HADLOCK, WA	
CHECKED	<i>SP</i>	DRAWING NO.	REV. G
MFG. APPR.	<i>SP</i>	D3391	SHEET 1 OF 8
APPROVED	<i>SP</i>	TITLE	SCALE
DE APPR.	<i>SP</i>	412 FLOAT SKIDTUBE	NTS
DATE	07.07.31	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY OTHER PURPOSE OR DISCLOSED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC	

NO. 412-38  
WORK ORDER  
RETURN TO  
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WITHOUT NOTICE

8 7 6 5 4 3 2 1



**RELEASED**  
07.11.04/14

QTY	PART NUMBER	DESCRIPTION
X	D3391-043	FLOAT SKIDTUBE ASSEMBLY
1	D3391-021	FWD TUBE ASSEMBLY
1	D3391-023	MID TUBE ASSEMBLY
1	D3391-025	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
24	AN3C4A	BOLT
12	AN3C6A	BOLT
8	AN3C7A	BOLT
44	AN960C10L	WASHER

#### GENERAL NOTES

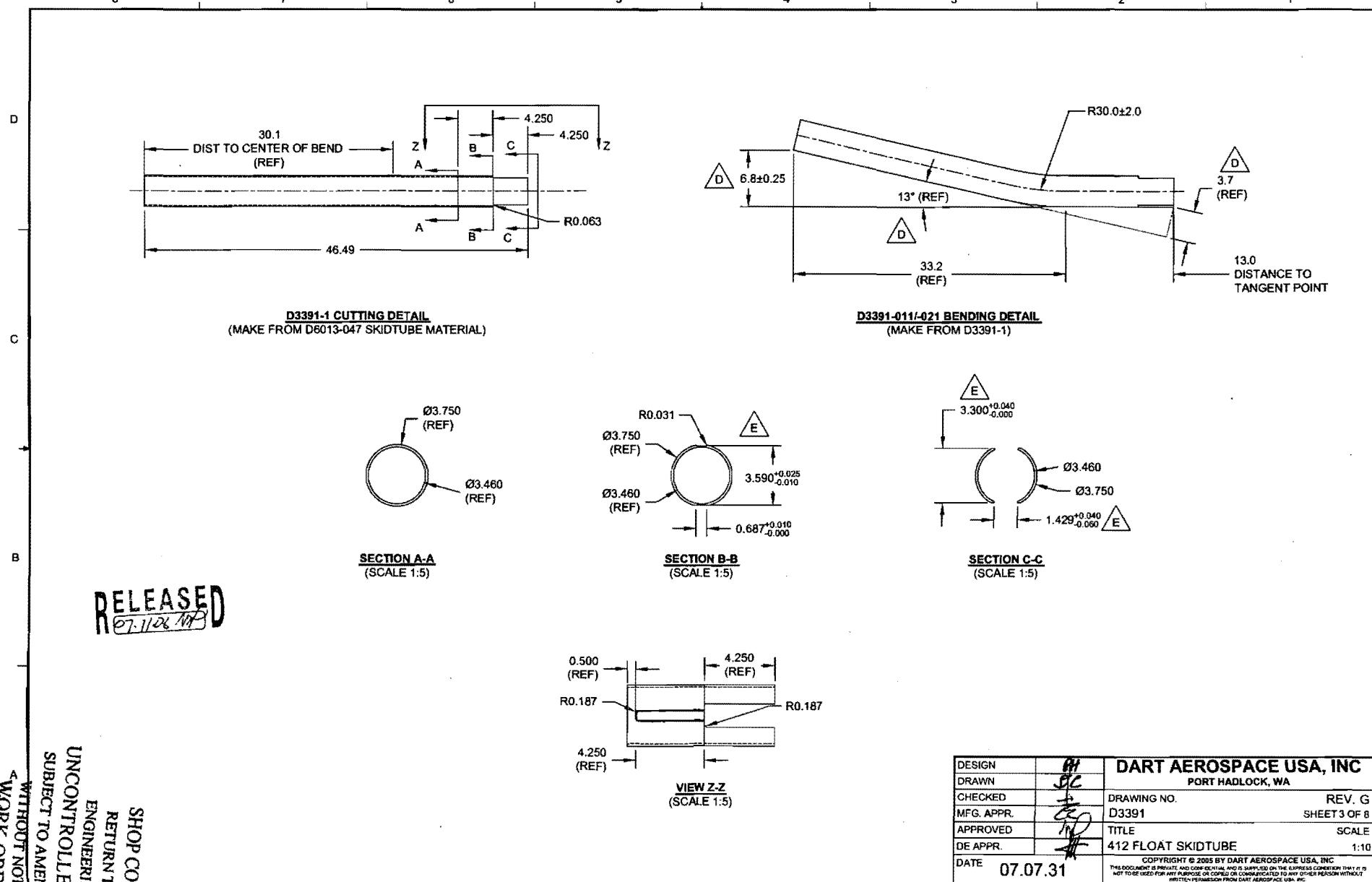
- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH  
AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH  
LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS  
OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0.297 SIZE HOLES  
FOR WEARSHOE INSERTS. CBORE AS NOTED AND INSTALL INSERTS EXCEPT  
WHERE INDICATED.

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DE APPR.	SC	TITLE	SCALE
		412 FLOAT SKIDTUBE	NTS
		DATE	07.07.31

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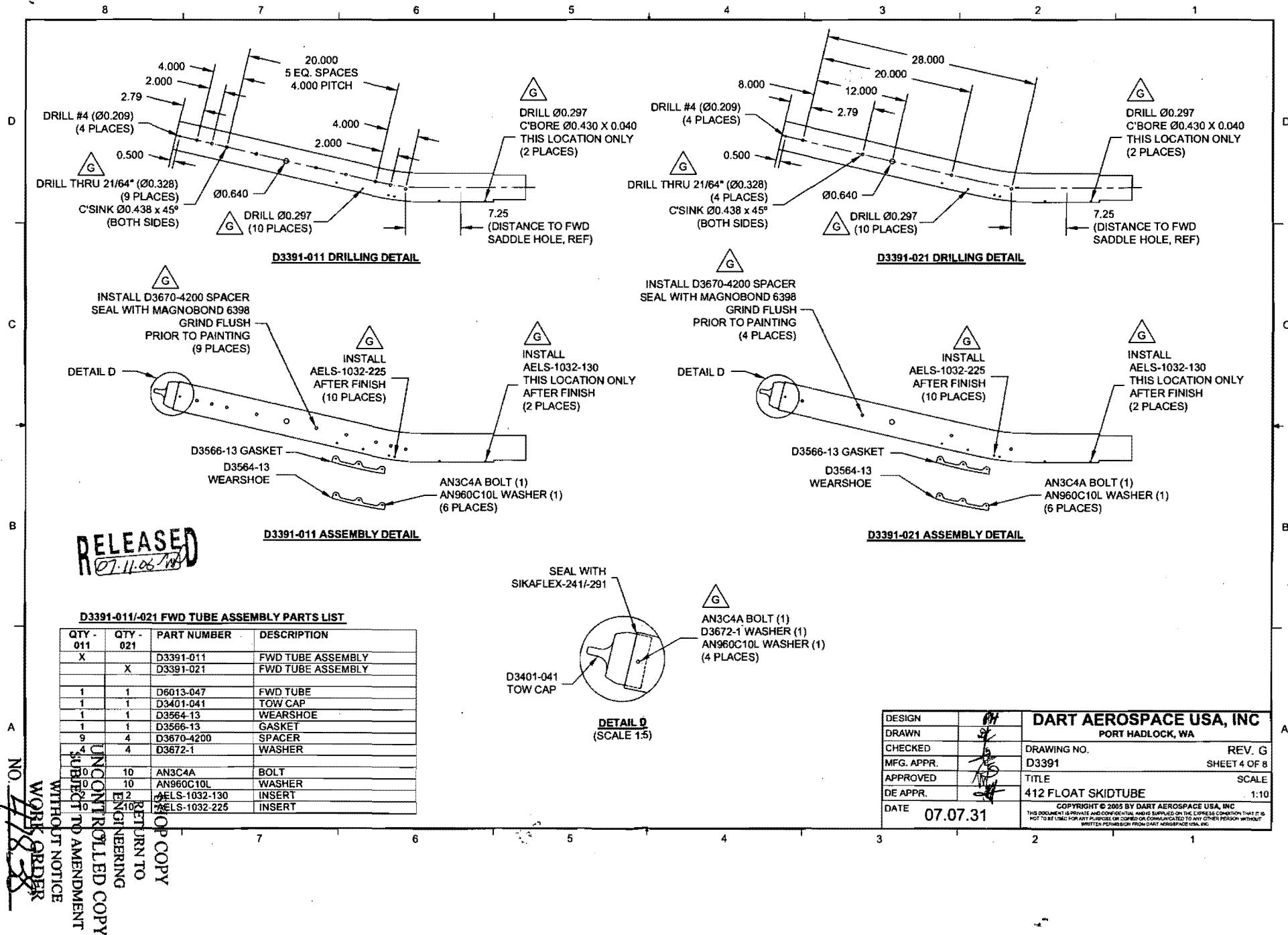
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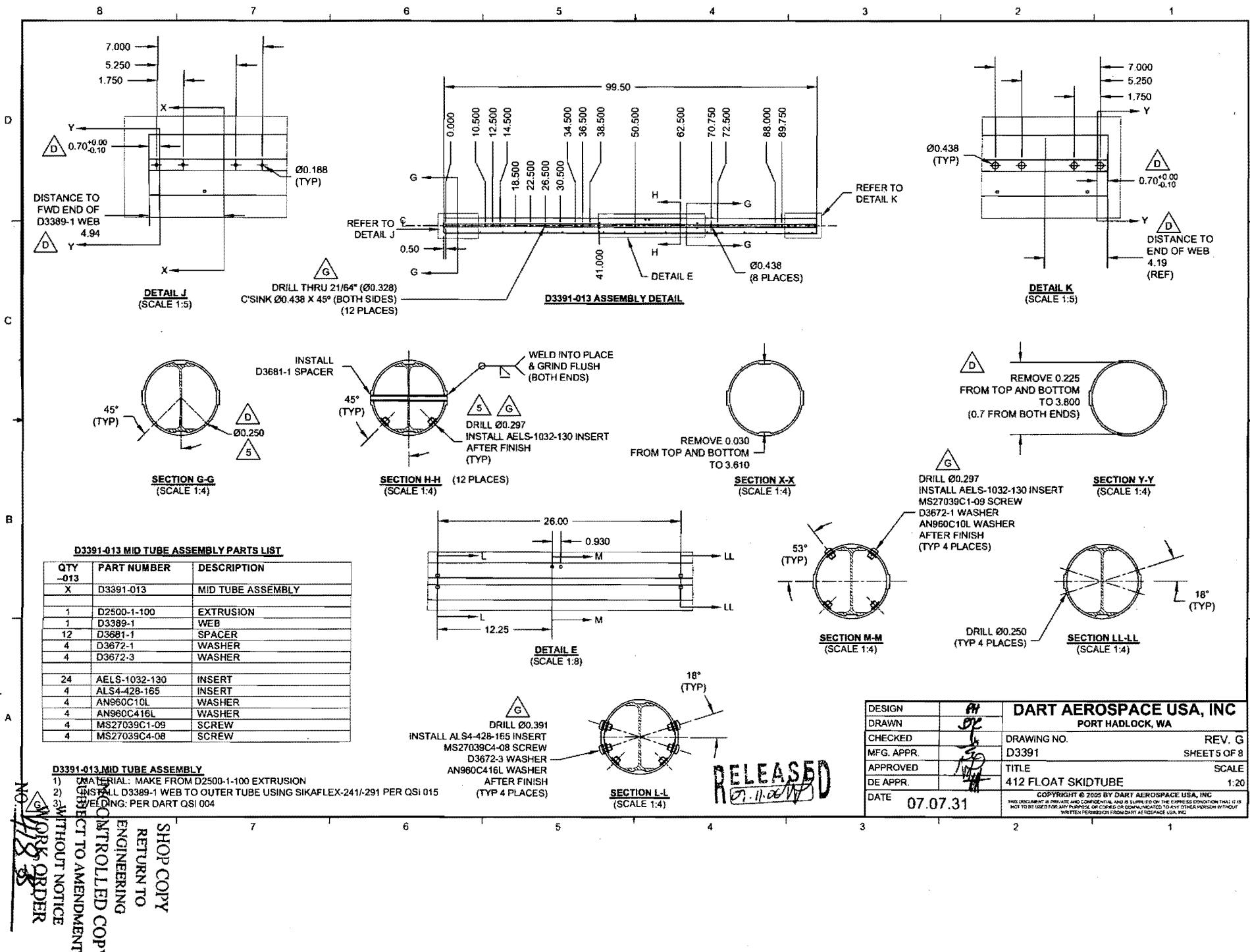
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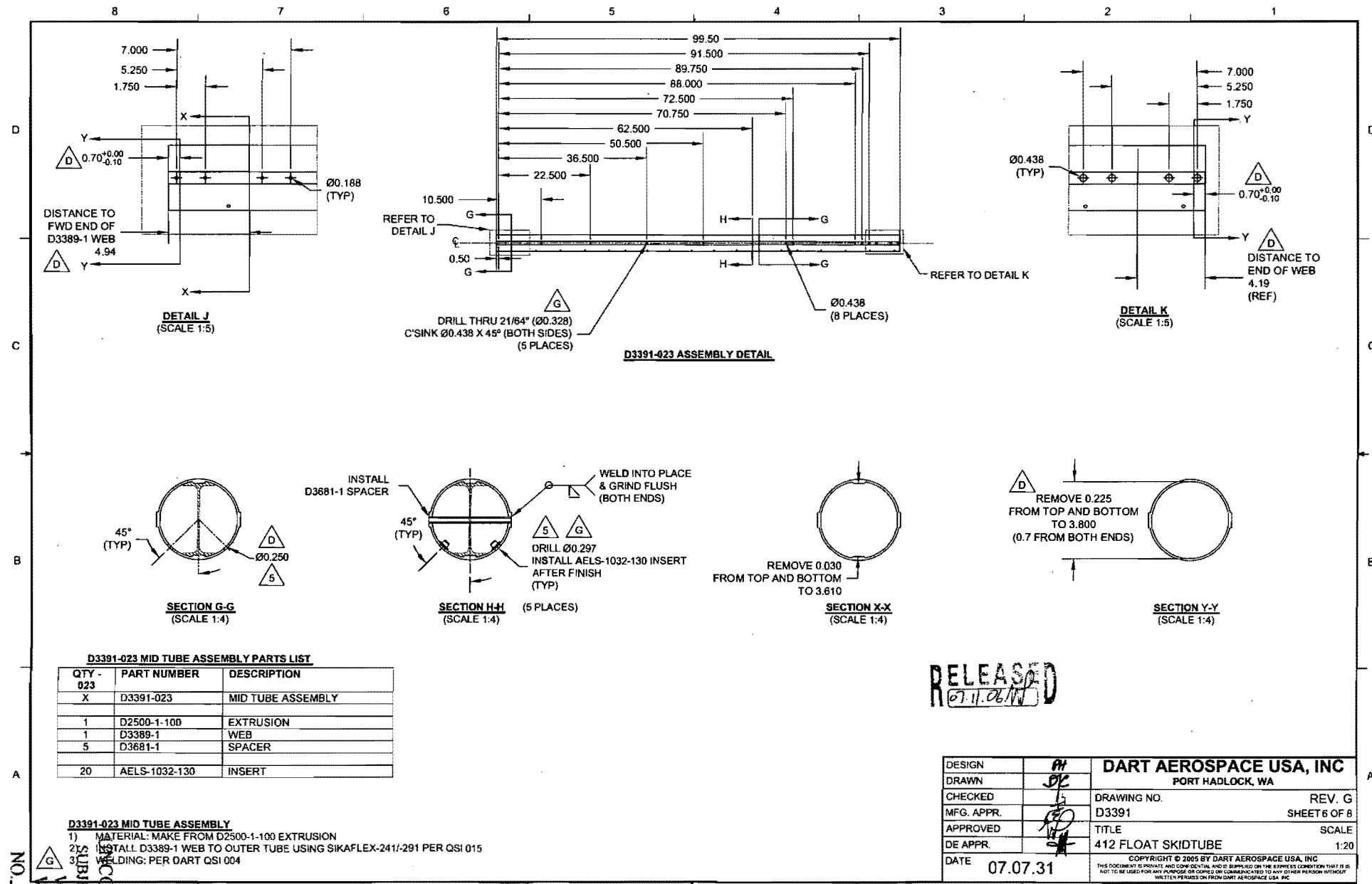


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APPROVED	<i>AV</i>	TITLE 412 FLOAT SKIDTUBE
DE APPR.	<i>AV</i>	SCALE 1:10
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